

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000097**Date Inspected:** 10-Mar-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Huang Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** N/A**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) Inspector, Alfredo Acuna was present as requested to observe fillet welds after macroetch tests for Procedure Qualification Records (PQR) HP200713 and HP200715. These test specimens were welded with the Flux Core Arc Welding (FCAW-G) process with the E71T-1 TWE-711 1.4 mm electrode, in the 2F (horizontal) and 3-F (vertical) positions. The test was performed per the AWS D1.5, Section 5.10.3. The macroetch test specimens on PQR HP200713 and HP200715 appeared to be in compliance with the contract documents with the exception of the multiple passes on PQR HP 200713 side 1A, 1B and 2B. These test coupons were rejected by ZPCM because the root of joint was not fused. The QA inspector performed dimensional inspections after ZPMC dimensional inspections and concurred with ZPMC recorded values. The results were as follows: PQR HP 200713 maximum single fillet weld 7.1 mm; PQR HP200715 maximum single fillet weld of 8.5 mm, and minimum multiple pass fillet weld of 11.4 mm. The QA inspector issued lot # B71-010-07 multiple passes and B71-012-07 single pass for PQR HP200713, and lot # B71-011-07 multiple passes and B71-013-07 single pass for PQR HP200715.

Summary of Conversations:

The QA inspector had a conversation with QA inspector Hu Gang. Mr. Hu relayed to the QA inspector that 2 multiple passes test specimens on PQR HP 200713, sides 1A, 1B and 2B failed because the root of joint were not fused. The QA inspector concurred with Mr. Hu.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Inspected By:	Acuna,Alfredo	Quality Assurance Inspector
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Reviewed By:	McClary,David	QA Reviewer
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